



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5569-1**Job Sheet 196779****Part No:** D5569-1**Job Qty:** 12 pcs**Part Name:** Replacement Blade - Stainless Steel**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 6/20/19**Job Tracking No:****Due Date:** 7/12/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG D5569-1 REV:C IPP REV A 18.08.30 NEW ISSUE RQ VERIFIED BY DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Mori Seiki TL-40 - 1	12 pcs		7/12/19	1.00	48.00	Mori Seiki TL-40 - 1		DAS 66 2019-06-29 9-89
110	QC 2	12 pcs		7/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		DAS 66 2019-06-29 9-89
							QC 2 - 64		

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Container No: S194977



Part: D5569-1

Job No: 196779

Serial No/Batch: S194977

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/02/19

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120 HAAS 5 Axis - B4B	12 pcs	7/12/19	0.75 24.00	HAAS - 5 - B4B		D.A. 19-07-10 / M.M. 2019/07/11
130 QC 2	12 pcs	7/12/19	0.00 0.00	QC 2 - 1		
				QC 2 - 12		
				QC 2 - 14		
				QC 2 - 17		
				QC 2 - 19		
				QC 2 - 2		
				QC 2 - 20		
				QC 2 - 22		
				QC 2 - 23		
				QC 2 - 25		
				QC 2 - 32		
				QC 2 - 33		
				QC 2 - 35		
				QC 2 - 39		
				QC 2 - 4		
				QC 2 - 40		
				QC 2 - 44		
				QC 2 - 45		
				QC 2 - 48		
				QC 2 - 49		
				QC 2 - 50		
				QC 2 - 51		
				QC 2 - 52		
				QC 2 - 57		
				QC 2 - 62		
				QC 2 - 63		
				QC 2 - 8		D.A. 19-07-10
				QC 2 - 66		
				QC 2 - 64		M.M. 2019/07/11
				QC 2 - 65		
				QC 2 - 5		
				QC 2 - 71		
				QC 2 - 73		
				QC 2 - 69		
140 QC 8	12 pcs	7/12/19	0.00 0.00	QC 8 - 12		M.L. 19/07/12
				QC 8 - 14		
				QC 8 - 17		
				QC 8 - 20		
				QC 8 - 25		
				QC 8 - 3		
				QC 8 - 32		
				QC 8 - 33		
				QC 8 - 35		
				QC 8 - 39		
				QC 8 - 4		
				QC 8 - 44		
				QC 8 - 45		
				QC 8 - 49		
				QC 8 - 58		
				QC 8 - 8		
				QC 8 - 9		
				QC 8 - 68		

						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
180	Powdercoat - 1 White GI(A)- B4B	12 pcs	7/12/19	0.00	0.42	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
190	QC 3	12 pcs	7/12/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
200	Packaging 3-1 - Stock - B4B	12 pcs	7/12/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	

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					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	12 pcs	7/12/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	JUL 16 2019
					QC 21 - SA - 53	

9-89

Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Cut blanks at 22.800" 2-Turn as per dwg. and folio

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - HAAS 5 Axis (HAAS CNC vertical machine #5) 1-Machine as per Folio FC306 and Dwg. D5569-1

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

190 - (QC3- Inspect Part Finish)

200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6020-160	Crosstube Material	1.7160 pcs (.143 ea)	100-Mori Seiki TL-40 - 1	F141822

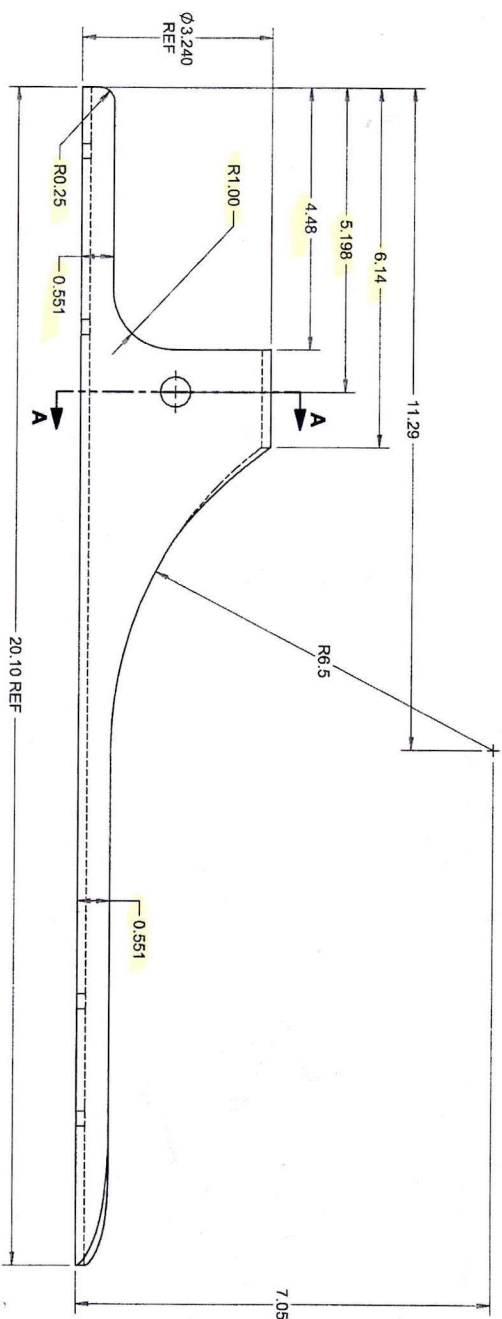
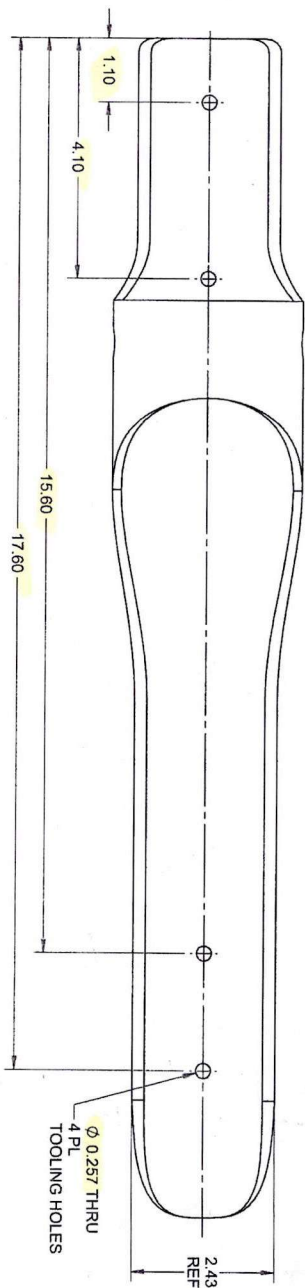
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6020-160	2	49	0

Part Specifications

Specifications could not be found.

Plex 6/20/19 1:59 PM Dart.lajeunesse.marie



D5569-1 SKIDTUBE BLADE

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 1967A

RELEASED

2019 JUN 19 WED

FCM 19-625

APPROVED

C	DELDED SHEET 1, 1 (-ISO VIEW), ADDED 3-60 ADDED OPTION TO MAKE .71TN FROM D9020-160	ZF	19.04.04
B	D5869-1 - REMOVED CHEMICAL CONVERSION COAT FROM FINISH - EXTENDED PORTION INTO SUTURE BY 2.600 WAS 1.68 TO 5.88 AND ASKED 43.5.198 WAS 2.588, 4.48 W5869-1.TNR. MAKE FROM M17-4R WAS D8008-132 DIM Ø3.240 WAS Ø3.25 STOCK REF. DIM 20.10 WAS 17.50	ZF	18.12.31
A	NEW ISSUE	ZF	17.09.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	NO		
APPROVED	NO		
DATE	CP		
	TITLE		
	SKIDTUBE BLADE		
	SCALE		
	NTS		

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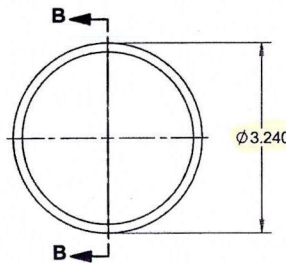
REV. C
 SHEET 1 OF 4

HAMMESBURY, ONTARIO, CANADA
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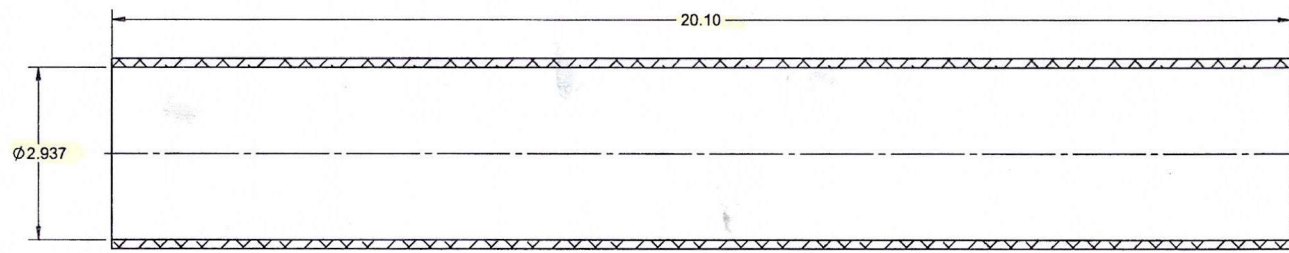
NOTES:

- 1) MATERIAL: MAKE FROM D5569-1TRN
- 2) FINISH: POWDER COAT WHITE 4.5, 1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK: SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6, 1
- 7) WEIGHT: 3.05 lbs

8 7 6 5 4 3 2 1



D5569-1TRN - TURNING DETAIL



SECTION B-B

NOTES:

- 1) MATERIAL: 17-4PH / S17400 / TYPE 630 SS ROUND BAR
PER AMS 5643 OR ASTM A564
H1025 CONDITION (HRC 32-42)
MIN. ULTIMATE TENSILE STRENGTH = 155 ksi
MIN. YIELD TENSILE STRENGTH = 145 ksi
REF DART SPEC M17-4-R-H1025
OR
MAKE FROM D6020-160
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.45 lbs

RELEASED
2019 JUN 19 NO

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	RQ	D5569	SHEET 2 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SKIDTUBE BLADE	NTS
DATE	19.04.04	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

